

Date: Thursday, 04/12/2008 9:10:52 AM
 User: Julie Dawson

Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING
Job Number	: 43901		
Estimate Number	: 13065		
P.O. Number	:	Part Number	: D2807041
This Issue	: 04/12/2008 S.O. No. :	Drawing Number	: D2807 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: E
Previous Run	: 35828	Material	:
Written By	:	Due Date	: 21/12/2008
Checked & Approved By	: <u>JUD 08.12.05</u>	Qty:	40 Um: Each
Comment	Est: D 07.11.12 ecn1019, replaces D2807 EC verified by DD Est Rev:E 08-02-12 ECN 1111 DD verified by: ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 7765

Order as per Dwg D2807

Possible supplier: Lift Support Technologies, Saskatoon, Canada

P/N 6/15-164/50-115N

Material release note is required

C 208/12/04

(40)

2.0

615 16450 115N

Gas Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 SUPPORT PROP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

R 8/12/16

(10)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/12/17

(40)

5.0

D36711

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 PLACARD
 batch: 43945

SS 08/12/18 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 9:10:52 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 43901

Part Number: D2807041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-install D3671-1 as per dwg D2807

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

8.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *48*

9.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR 08-12-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

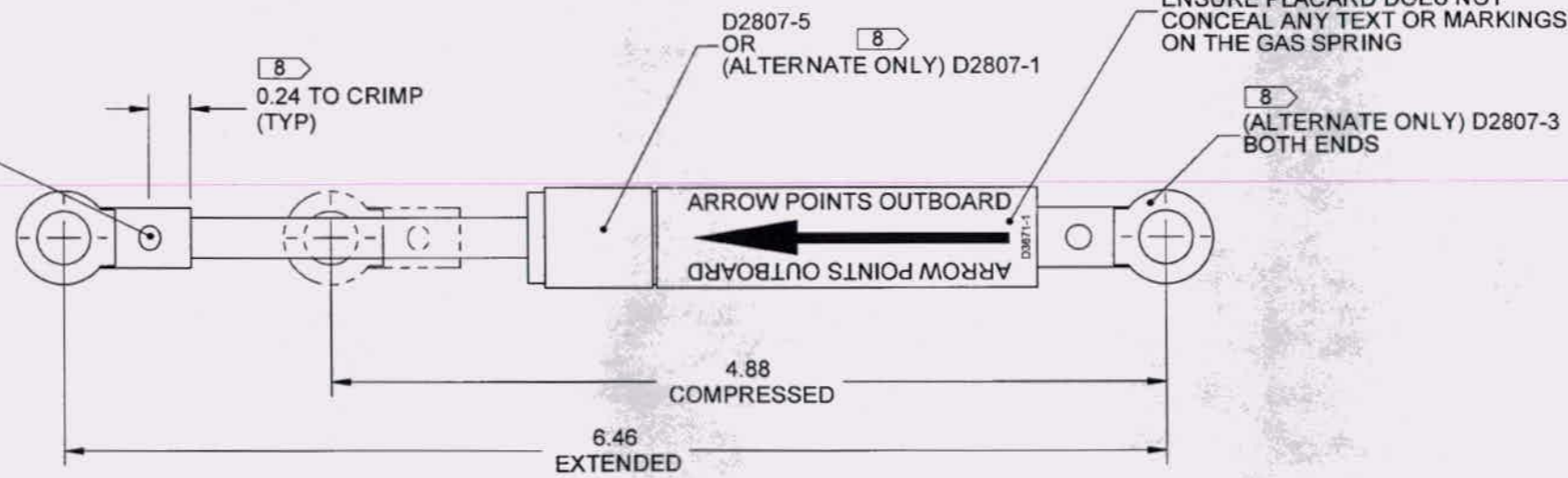
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG



D2807-041 GAS SPRING

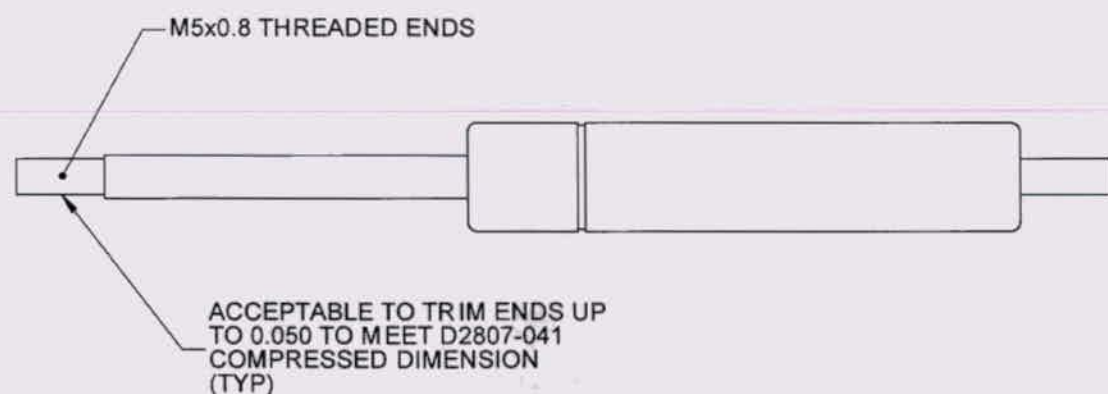
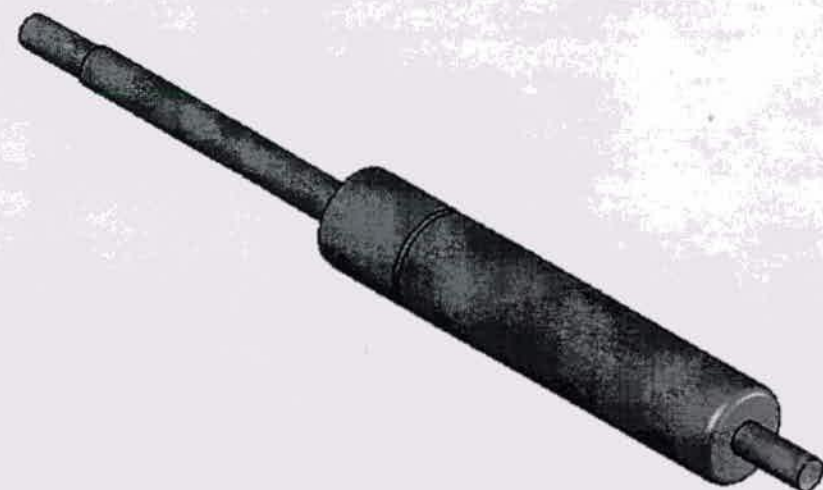
D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.169 LBS
8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43901

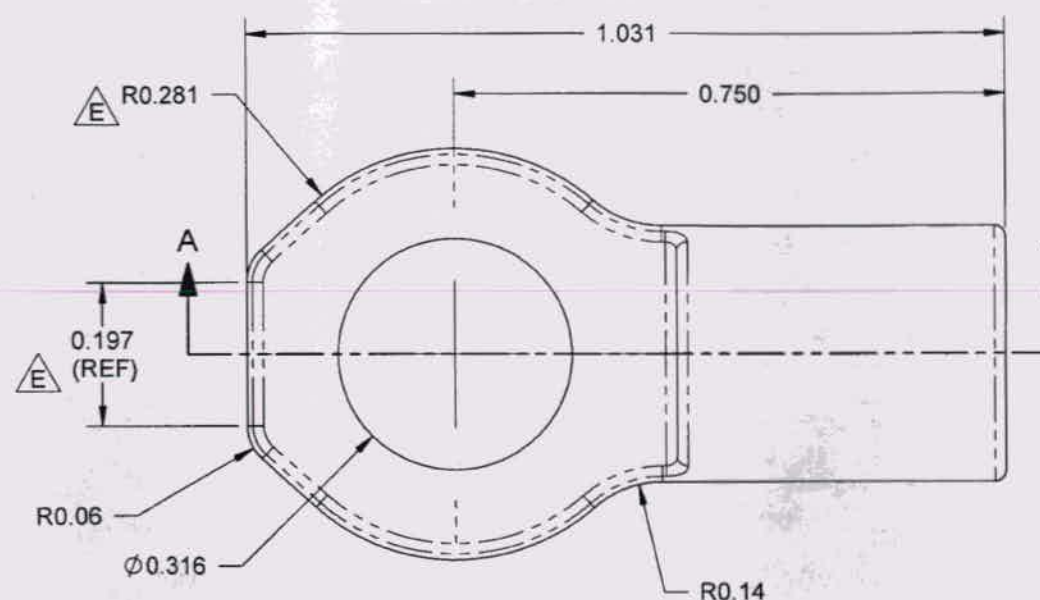
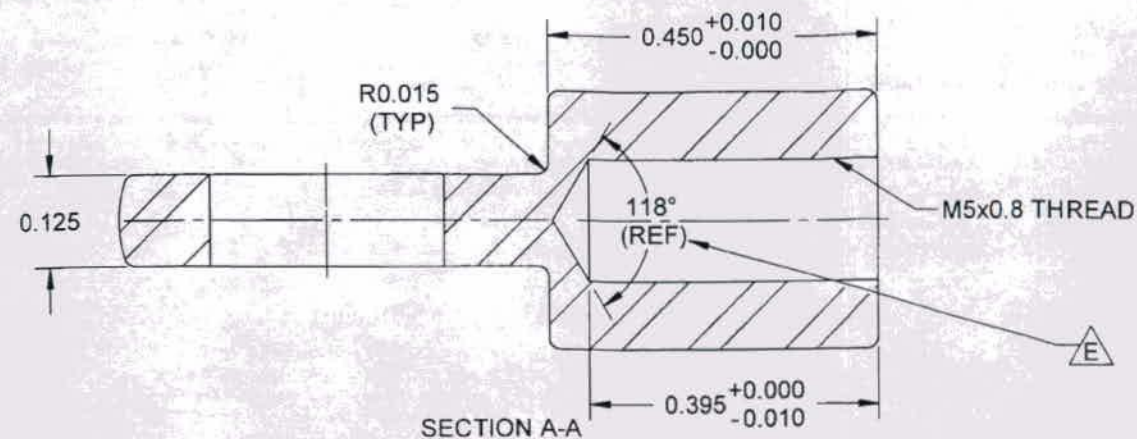
E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AT		
CHECKED	IE	DRAWING NO.	REV. E
MFG. APPR.	AT	D2807	SHEET 1 OF 3
APPROVED	AT	TITLE	SCALE
DE APPR.	AT	GAS SPRING	NTS
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



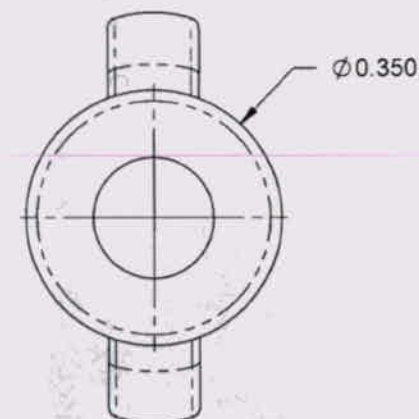
D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



D2807-3 LUG

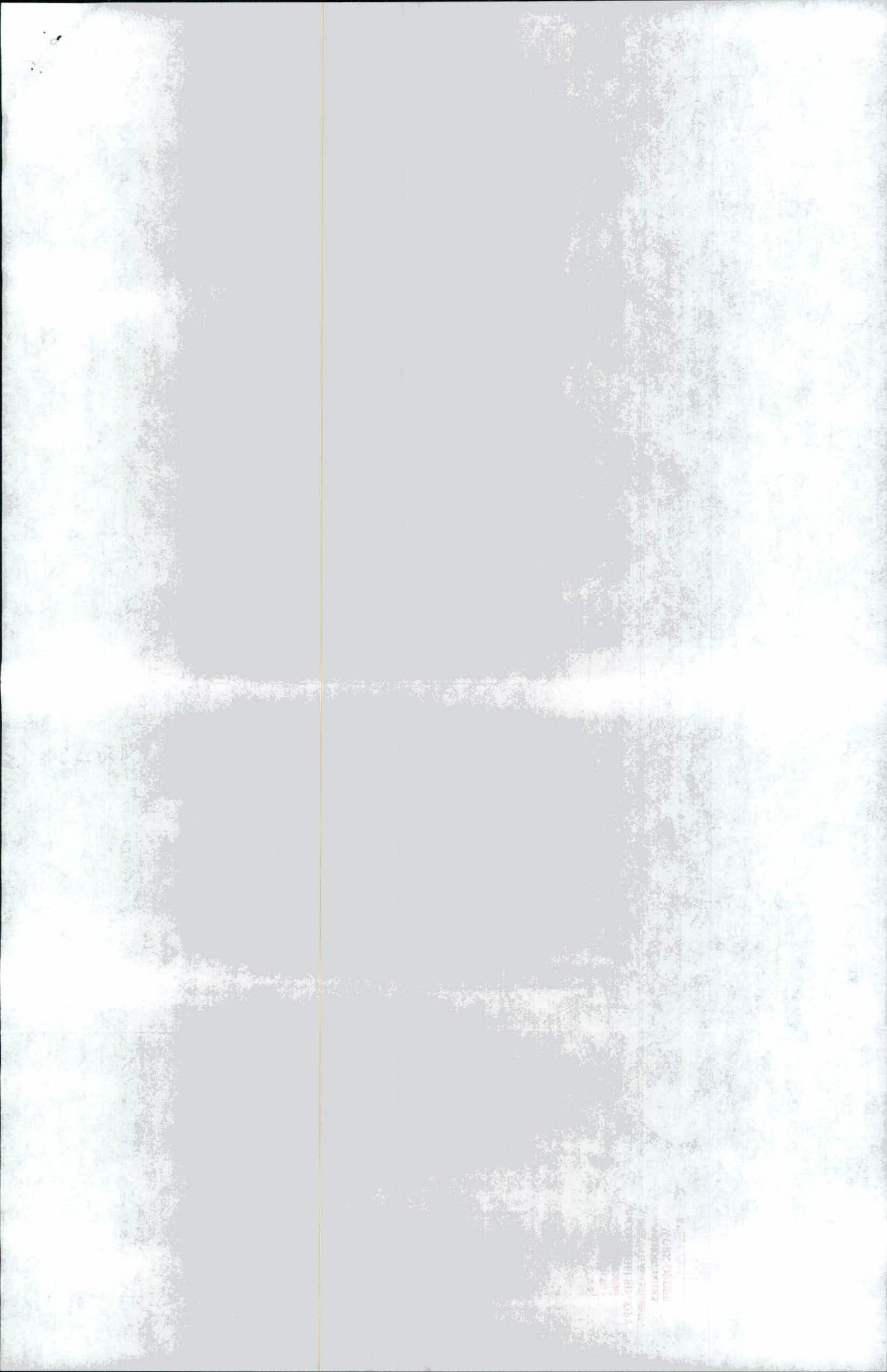


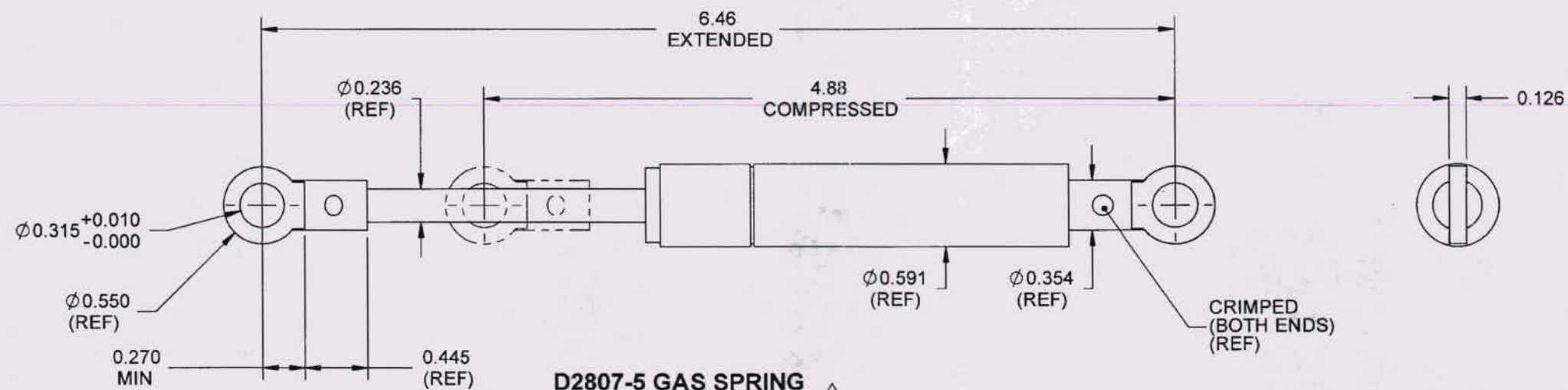
D2807-3 LUG NOTES:


- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.	11	D2807	SHEET 2 OF 3
APPROVED	11	TITLE	SCALE
DE APPR.	11	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43901





D2807-5 GAS SPRING 

D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2807	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43901

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK
S7N 1Y9

Packing Slip

Date	Packing Slip #
12/15/2008	4606

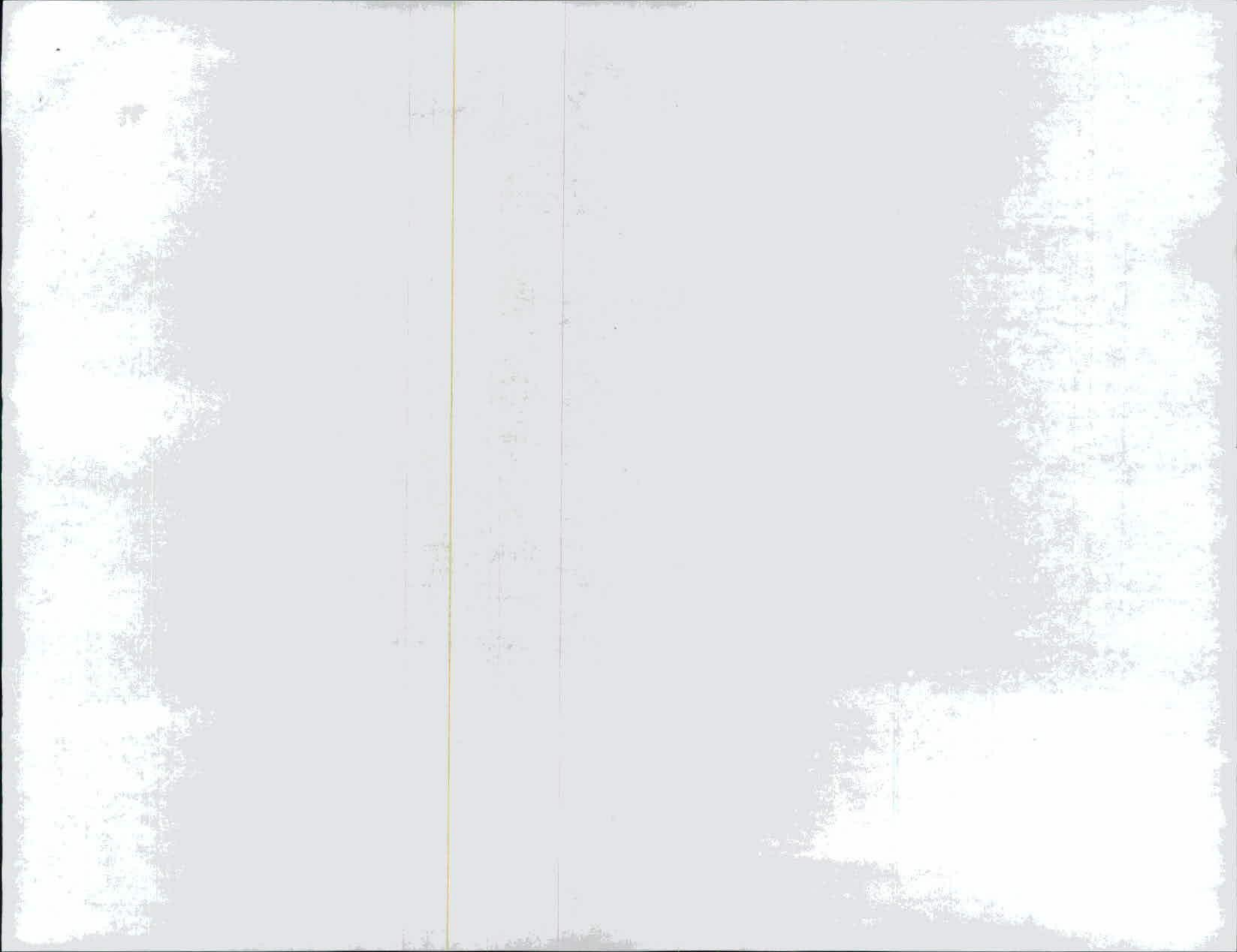
Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

P.O. No.	Rep	Ship Date	Ship Via
7765	Nolan	12/15/2008	Purolator

Qty	Description
10	D2807 - 6/15-056-168-115N Stainless Gas Spring
	Shipping via PUROLATOR Collect - Tracking # 329057690318
	30 pcs on back order
	Total GST
	Business Number: 875007718

Please remit to above address. Thank you for the business.





P.O. Box 25032, Saskatoon, Saskatchewan, Canada S7K 8B7
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: info@lsttechnologies.ca
Web: www.lsttechnologies.ca

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

10 Units: D2807 – 615 16450 115N Gas Spring

Country of Manufacture: Canada

Date of Manufacture : 2008

This product is ROHS compliant.

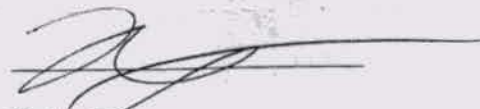
S
08/12/17

We certify no mercury was used in the manufacture of this order.

Purchase Order # 00007765

Invoice # 4606

L S Technologies Inc Canada


Nolan Fehr
Manager

